

CLAIM AMENDMENTS

1-8. (Canceled)

9. (New) A method of making a socket on a pipe made of copper, steel or alloys of Cu, Ni and Fe, by an at least single-step expansion of a pipe end with a large jump in diameter, comprising:

introducing an expansion tool axially into the pipe end, and

at least partially upsetting an expanded region or a region to be expanded of the pipe end simultaneously with and/or subsequently to introduction of the expansion tool into the pipe end by a force applied axially to the pipe end while limiting an outer diameter of the pipe end to be processed by at least one shaping shoe at least partially surrounding the pipe end.

10. (New) The method as defined in claim 9, wherein, in case of a multi-step expansion of the pipe end, only the region of the pipe end to be expanded or the expanded region of the pipe end of largest diameter is upset.

11. (New) The method as defined in claim 9, wherein the region of the pipe end to be expanded or the expanded region of the pipe end is upset to such an extent that the wall thickness is increased in the upset portion up to the wall thickness of the rest of the pipe or at least up to the wall thickness of the previously expanded portion.

12. (New) The method as defined in claim 9, wherein the upset pipe ends are inwardly flanged for receiving sealing elements.

13. (New) The method as defined in claim 10, wherein the region of the pipe end to be expanded or the expanded region of the pipe end is upset to such an extent that the wall thickness is increased in the upset portion up to the wall thickness of the rest of the pipe or at least up to the wall thickness of the previously expanded portion.

14. (New) The method as defined in claim 10, wherein the upset pipe ends are inwardly flanged for receiving sealing elements.

15. (New) The method as defined in claim 11, wherein the upset pipe ends are inwardly flanged for receiving sealing elements.

16. (New) An apparatus for making a socket on a pipe end, comprising:
an expansion tool which is axially introducible into the pipe end and which has one or more conical and cylindrical parts adapted to determine a subsequent inner diameter of the pipe end,

at least one shaping shoe having conical and cylindrical parts adapted to determine a subsequent outer diameter of the pipe end, and

a substantially cylindrically structured upsetting device having a smallest inner diameter which corresponds, with necessary play, to a maximum outer diameter of the expansion tool and a substantially radially extending annular shoulder which is pressable axially against an end face of the pipe end during an upsetting step.

17. (New) The apparatus as defined in claim 16, wherein, on its side oriented toward the pipe end, the expansion tool has a cylindrical part which adjoins the shoulder and having an inner diameter which determines the greatest diameter of that enlarged outer diameter of a cylindrical part of the pipe end which is reached after the upsetting step.

18. (New) The apparatus as defined in claim 17, wherein the inner diameter of the cylindrical part corresponds to a maximum inner diameter of the at least one shaping shoe.

19. (New) The apparatus as defined in claim 17, wherein an axial length of the cylindrical part is greater than or equal to a length of a cylindrical part of a shaping shoe which has a largest inner diameter.

20. (New) The apparatus as defined in claim 15, wherein an axial length of the cylindrical part is greater than or equal to a length of a cylindrical part of a shaping shoe which has a largest inner diameter.